

Date: Wednesday, 5/10/2006 9:19:40 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BASKET BASE ASSEMBLY (350)		
Job Number	: 27049A		Part Number	: D2221		
Estimate Number	: 10189		Drawing Number	: D2221/D2235		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 5/10/2006 S.O. No. : N/A		Drawing Revision	: F/B1		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 5/30/2006 Qty: 1 Um: Each		
Previous Run	: 27048A					
Written By	: <u>Self</u> (Comment Below)					
Checked & Approved By	: <u>Self</u> 06-05-10					
Comment	: Est Rev: J 05.09.02 Added D3442-1KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :									
1.0	D31661	Basket Hoop									
<p>Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)</p> <p>Pick:</p> <table> <tr> <td>Qty</td> <td>Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>4</td> <td>D3166-1</td> <td>RIB</td> <td><u>B26217</u></td> </tr> </table> <p><u>106/05/17</u></p>				Qty	Part Number	Description	Batch	4	D3166-1	RIB	<u>B26217</u>
Qty	Part Number	Description	Batch								
4	D3166-1	RIB	<u>B26217</u>								
2.0	D22323	Basket Hinge									
<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)</p> <p>Pick:</p> <table> <tr> <td>Qty</td> <td>Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>2</td> <td>D2232-3</td> <td>Hinge bracket</td> <td><u>B24527 / B25239</u></td> </tr> </table> <p><u>106/05/24</u></p>				Qty	Part Number	Description	Batch	2	D2232-3	Hinge bracket	<u>B24527 / B25239</u>
Qty	Part Number	Description	Batch								
2	D2232-3	Hinge bracket	<u>B24527 / B25239</u>								
3.0	D2325	Support Gusset (350 Bask)									
<p>Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)</p> <p>Pick:</p> <table> <tr> <td>Qty</td> <td>Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>4</td> <td>D2325</td> <td>Support Gusset</td> <td><u>B26922</u></td> </tr> </table> <p><u>106/05/24</u></p>				Qty	Part Number	Description	Batch	4	D2325	Support Gusset	<u>B26922</u>
Qty	Part Number	Description	Batch								
4	D2325	Support Gusset	<u>B26922</u>								
4.0	D23273	Spacer Bushing									
<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)</p> <p>Pick:</p> <table> <tr> <td>Qty</td> <td>Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>2</td> <td>D2327-3</td> <td>Bushing</td> <td><u>B25823</u></td> </tr> </table> <p><u>106/05/24</u></p>				Qty	Part Number	Description	Batch	2	D2327-3	Bushing	<u>B25823</u>
Qty	Part Number	Description	Batch								
2	D2327-3	Bushing	<u>B25823</u>								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Wednesday, 5/10/2006 9:19:40 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 27049A

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D2581 Mounting Bracket B26204

11/06/05/24

6.0 D34421 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3442-1 Shim B26739

11/06/05/24

7.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 39.6900 sf(s)/Unit Total : 39.6900 sf(s)

Pick:

Qty Part Number Description Batch
36 sf M304EX0.75-16F Expanded Metal M100981

11/06/05/24

8.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing
Batch: M100783

11/06/05/17

9.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

11/06/05/24

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

W/O:		WORK ORDER CHANGES					
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 6/6/01 Date: 06/06/01
 NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 5/10/2006 9:19:41 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 27049A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

① 06-05-24 ①

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

② 06/05/29 ②

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

③ 06-05-30 ③

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Seal support gusset seam with white sikaflex-291 Batch: M100901

Expiry date: 11/2006

④ 06-05-28 ④

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

⑤ 06/06/01 ⑤

Job Completion



⑥ 06-06-01 ⑥

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

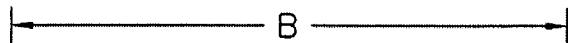
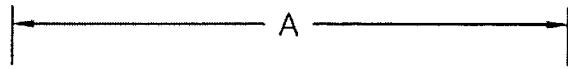


DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2221	REV. F SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE NTS
C	95.11.21	SEPARATE BASKET AND LID	
D	96.06.21	CHANGE LATCH	
E	01.04.19	CHANGE HINGE	
F	05.06.07	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS	

RELEASED

05.08.19 *[initials]*PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	—	96.00	RIB
D2221-3	2	—	25.50	RIB
D2221-5	2	18.88	—	RIB
D2221-7	1	55.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM



45°
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WITHOUT NOTICE

WORK ORDER
NO 27049A

D2221-1/-3/-5/-7

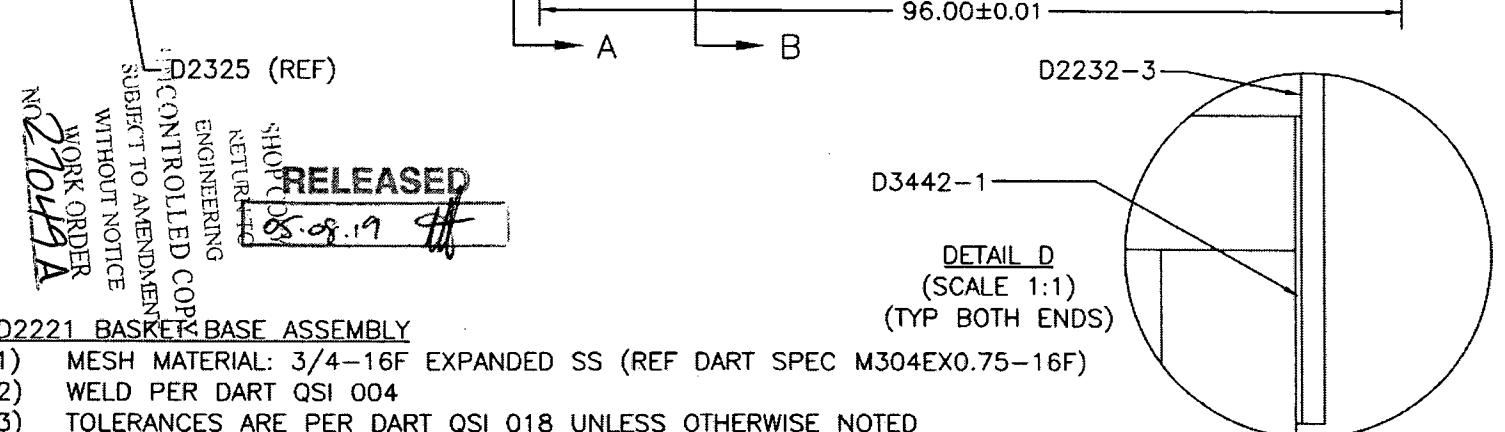
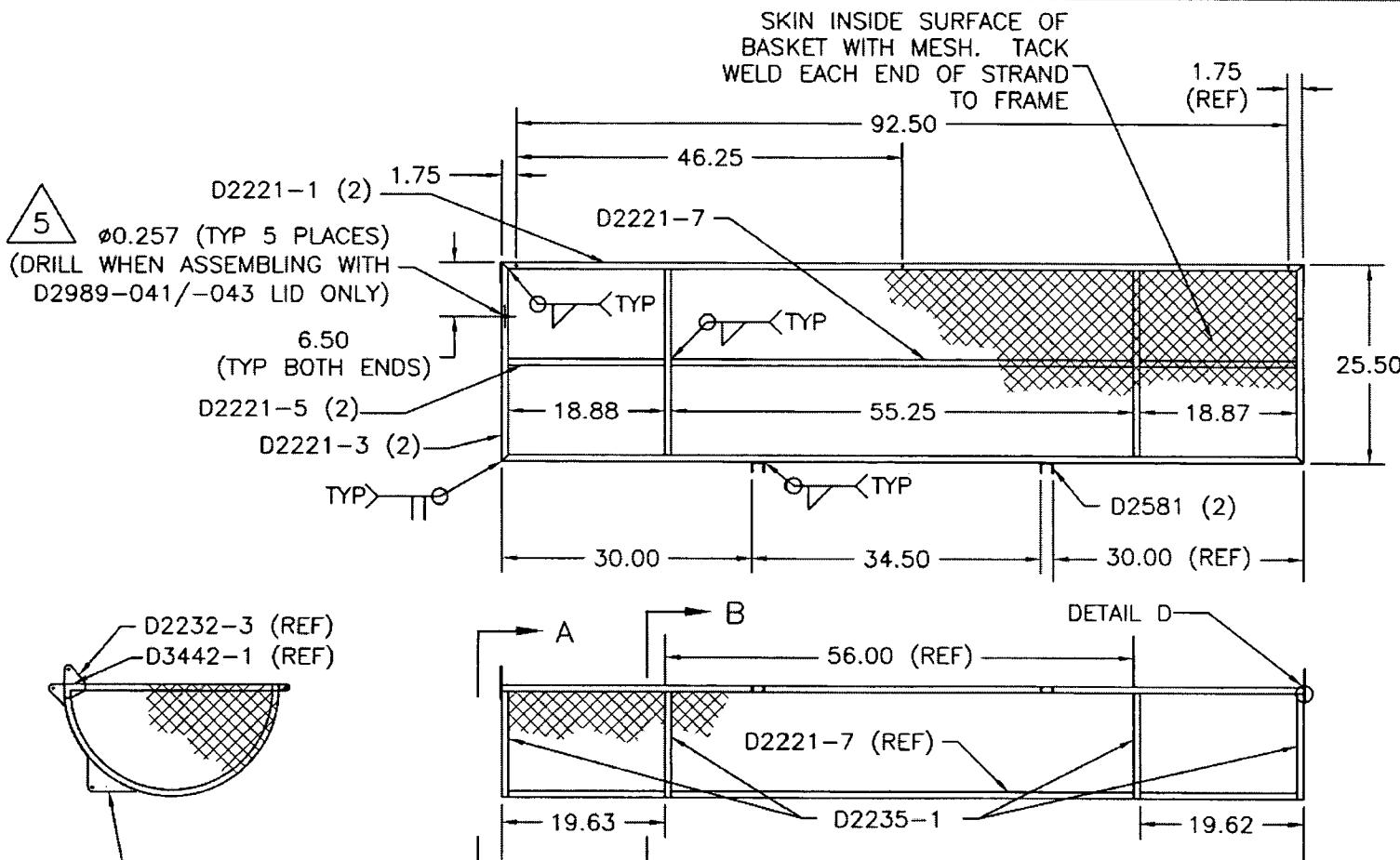
- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
(REF. DART SPEC M304TS0.750W.060)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL Ø0.257 HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH
D2989-041/-043 BASKET LID

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DART

DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED DATE 05.06.07	APPROVED TITLE D2221	DRAWING NO. SHEET 2 OF 3 SCALE 1:20

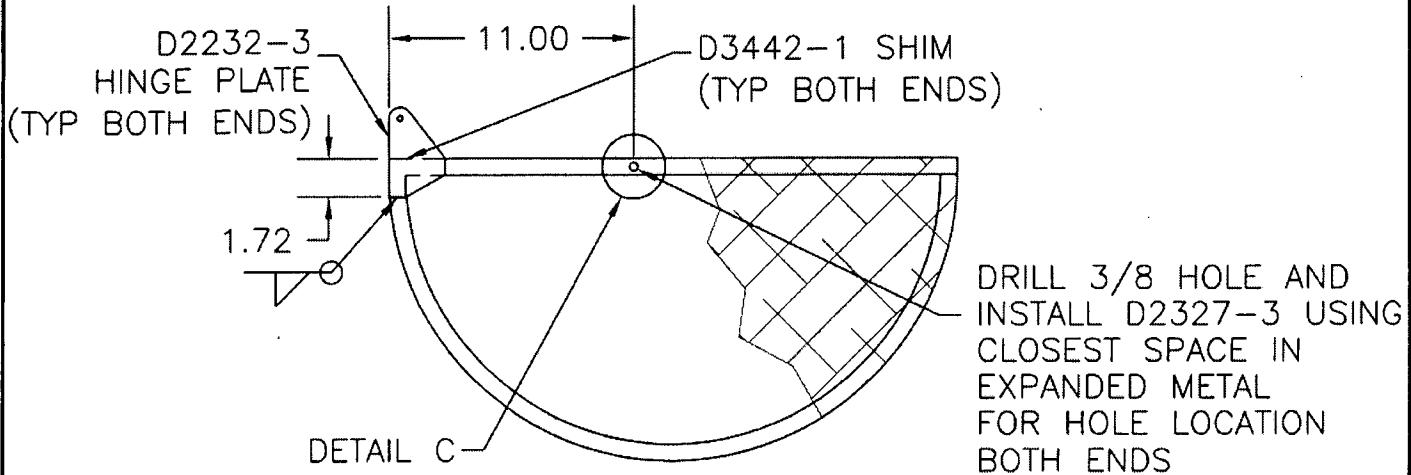
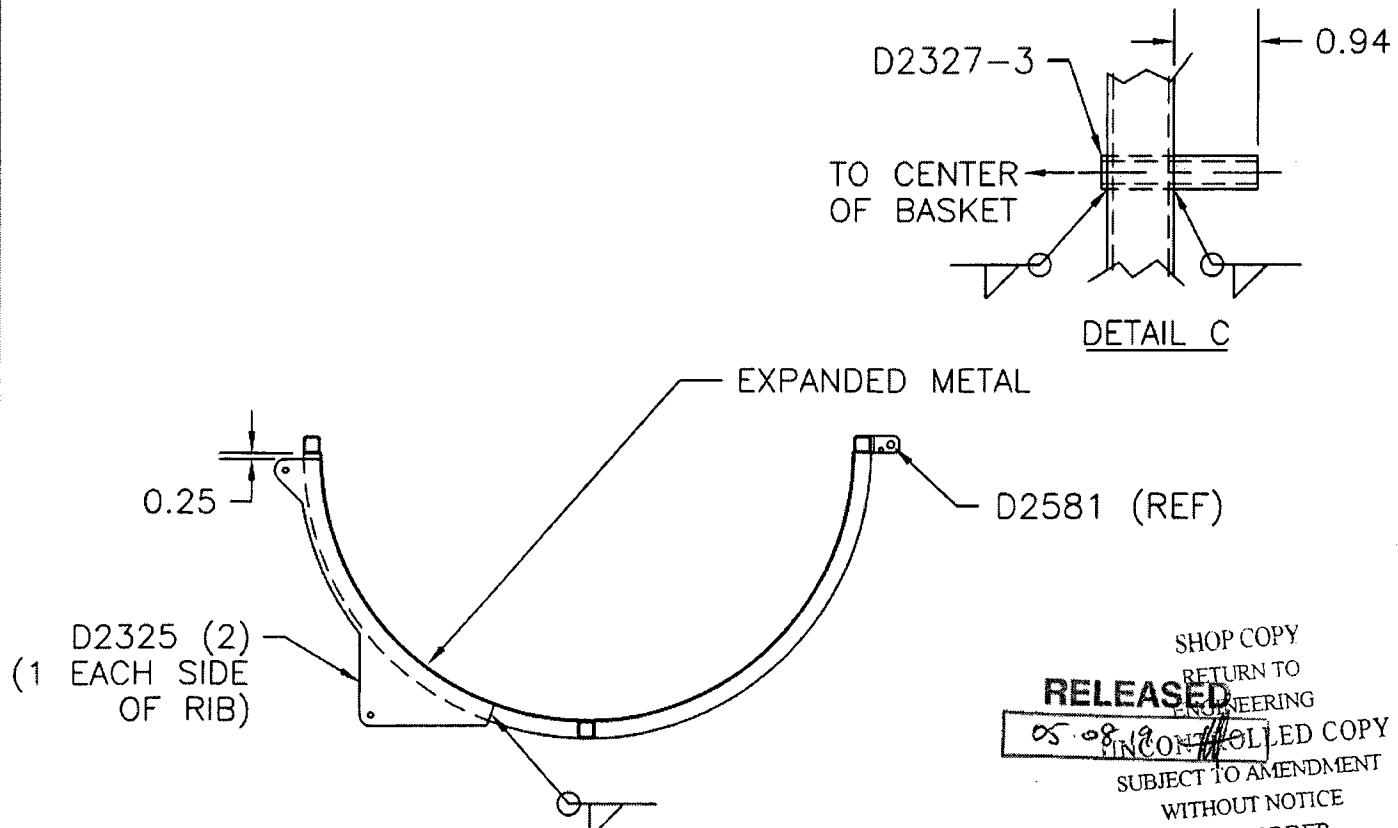


D2221 BASKET BASE ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

DART

DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2221	REV. F SHEET 3 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE 1:8

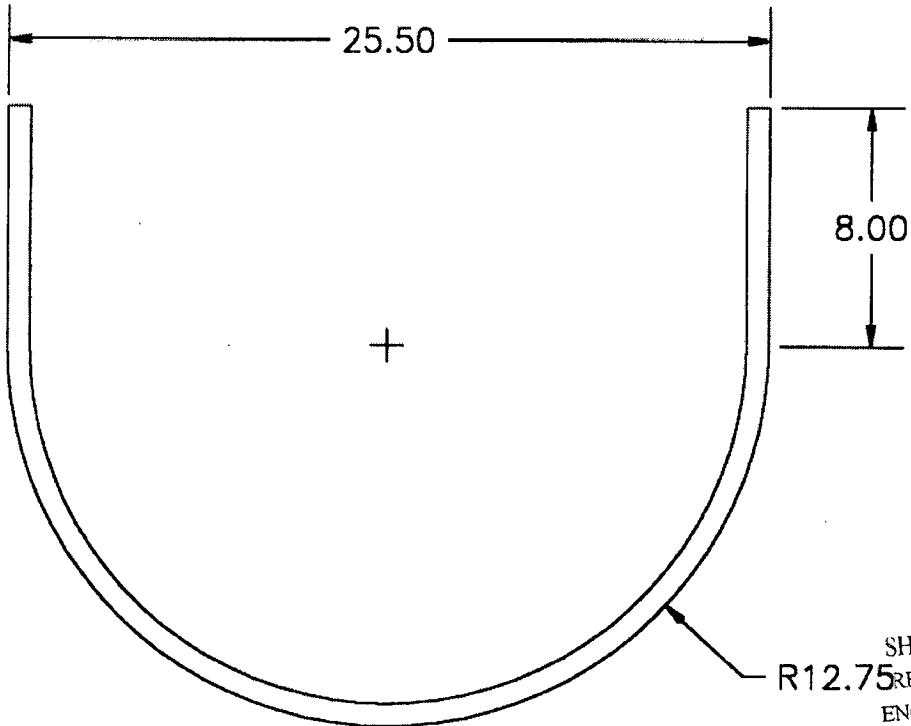
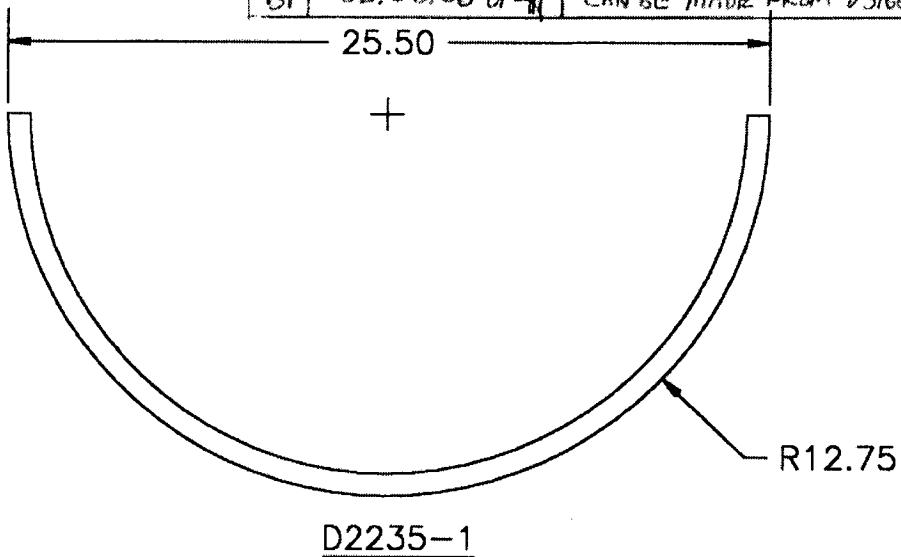
SECTION A-A SAME BOTH END RIBSSECTION B-B SAME BOTH CENTER RIBS

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DART

DESIGN B. WILLIAMS	DRAWN BY B. WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2235
DATE 94:12:16		REV. B SHEET 1 OF 1 TITLE BASKET RIBS SCALE

BI 02.08.06 *1/1* CAN BE MADE FROM D3166-1**RELEASED**
R 960507

CAN BE MADE FROM D3166-1 BI

MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR. NO. 27049A

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NO. 27049A

